

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023952**Date Inspected:** 12-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA

<b>CWI Name:</b>	Ruben Dominguez, Chris Concha			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006 L & R**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

**E2/E3 Bike Path Traveler**

This QA Inspector randomly observed WMI production personnel Mr. Larry Swanson ID#3058, performing layout, fitting and tack welding activities at various locations for the E2/E3 Bike Path Traveler Assemblies. This QA Inspector observed Mr. Swanson performing the FCAW in all positions randomly throughout the shift.

**E2/E3-WB Traveler**

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding activities at various locations for the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Fuentes performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions randomly throughout the shift.

**SAS/E2-E3 Elevating Platforms**

QA Inspector observed no work on the SAS/E2-E3 Elevating Platforms Assemblies on this date.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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### SAS-WB Traveler – Lower Truss Frame Assembly

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Lower Truss Frame Assemblies.

This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the am shift. Welding Completed on the SAS-WB Traveler – Lower Truss Frame Assembly on this date. QA Inspector randomly observed Smith Emery, CWI, QC Inspector's Mr. Ruben Dominguez and Mr. Chris Concha performing visual inspection on the Lower Truss Frame Assembly. Mr. Dominguez informed QA Inspector that Smith Emery did not completed visual inspection on this date.

### SAS-WB Traveler - Fixed Stair Section

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and helper Mr. Jesus Rayas WID#3197, performing layout, fitting and tack welding activities at various locations for the SAS-WB Traveler Fixed Stair Section Assemblies. This QA Inspector observed Mr. Canales performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Fixed Stair Section Assemblies. This QA Inspector observed Mr. Newton performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Fixed Stair Section Assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the am shift.

### Traveler Test Rack

This QA Inspector observed no WMI production personnel performing fitting, welding or cutting activities on assemblies for the Traveler Test Rack.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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### QA NDT

QA Inspector performed Magnetic Particle Testing on the Traveler Trolley Train Assemblies. See Caltrans Magnetic Particle Test Report TL-6028 dated May 12, 2011 for more detailed information.

### QA NDT

QA Inspector performed Ultrasonic Testing on the SAS-WB Traveler, Lower Truss Section and the Fixed Stair Section. See Caltrans Ultrasonic Test Report TL-6027 dated May 12, 2011 for more detailed information.



### Summary of Conversations:

QA Inspector was informed by RPI Mr. Carlos Torres that RPI should be starting to blast and prime coat on Monday 5-16-11. Mr. Torres stated that RPI will be working from 0700 hour to approximately 1530 hour all of next week. Mr. Torres stated that RPI will be doing blasting, and prime coating on the Suspension Arms and some items from the Trolley Train assemblies.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brannon, Sherri	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz, Joe	QA Reviewer

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